

5164580



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D135-1027-153
Job Sheet 190560



Part No: D135-1027-153

Job Qty: 1 pcs

Part Name: Mid Height Fwd Crosstube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/11/19

Job Tracking No:

Due Date: 3/29/19

Created By: Jesse White

Type: SOLD

Description:

Note: D135-1027-153 REV.B IPP REV:A 17.01.24 NEW ISSUE DD VERF:JLM IPP REV:B 18.01.02 AS PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Handfinish - 1 - Chemical	1 pcs	3/29/19		0.00	0.17	Handfinish - 1 - 1	
							Handfinish - 1 - 2	
							Handfinish - 1 - 3	
							Handfinish - 1 - 4	
							Handfinish - 1 - 5	
							Handfinish - 1 - 6	
							Handfinish - 1 - 7	
							Handfinish - 1 - 8	
							Handfinish - 1 - 9	
							Handfinish - 1 - 10	
							Handfinish - 1 - 11	
							Handfinish - 1 - 12	
							Handfinish - 1 - 13	
							Handfinish - 1 - 14	
							Handfinish - 1 - 15	
							Handfinish - 1 - 16	
							Handfinish - 1 - 17	
							Handfinish - 1 - 18	
							Handfinish - 1 - 19	
							Handfinish - 1 - 20	
							Handfinish - 1 - 21	
							Handfinish - 1 - 22	
105	QC 7	1 pcs	3/29/19		0.00	0.00	QC 7 - 10	
							QC 7 - 13	
							QC 7 - 14	
							QC 7 - 15	
							QC 7 - 17	
							QC 7 - 18	
							QC 7 - 19	
							QC 7 - 2	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S164580



Part: D135-1027-153

Job No: 190560

Serial No/Batch: S164580

Revision: B

Inspector:

Exp Date:

Instructions:

Date: 03/21/19

DAS
10
9-89

					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	JW
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
110	Purchasing	1 pcs	3/29/19	0.00 0.00	Purchasing - 1	03/21/2019 PL
	Outsource 23 Tube bending				Purchasing - 2	
					Purchasing - 3	
120	Packaging 2-1 - Receive - B4B	1 pcs	3/29/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	JW 19-03-21
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
130	QC 6	1 pcs	3/29/19	0.00 0.00	QC 6 - 42	
					QC 6 - 9	PD 19-03-25

					QC 6 - 68	
					QC 6 - 61	
132	Crosstubes - 2 - B4B	1 pcs	3/29/19	0.00 1.00	Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	BB/6P 19-6-E
					Crosstubes - 4 - B4B	
135	QC 15	1 pcs	3/29/19	0.00 0.00	QC 15 - 12	
					QC 15 - 3	
					QC 15 - 47	
					QC 15 - 49	
					QC 15 - 58	DAS
					QC 15 - 9	JUN 14 2019 68
140	Outsource	1 pcs	3/29/19		SKY002-VC	2 JUN 14 2019 89
150	Packaging 2-2 - Receive - B4B	1 pcs	3/29/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	JUN 17 2019
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
160	QC 6	1 pcs	3/29/19	0.00 0.00	QC 6 - 42	
					QC 6 - 9	JUN 17 2019 DAS
					QC 6 - 68	40
					QC 6 - 61	9-89
170	Packaging 3-1 - Stock - B4B	1 pcs	3/29/19	0.00 0.00	Packaging 3-1	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	

					Packaging 3 - 6 - B4B					
					Packaging 3 - 7 - B4B					
					Packaging 3 - 8 - B4B					
					Packaging 3 - 9 - B4B					
					Packaging 3 - 10 - B4B					
					Packaging 3 - 11 - B4B					
					Packaging 3 - 12 - B4B					
					Packaging 3 - 13 - B4B					
					Packaging 3 - 14 - B4B					
					Packaging 3 - 15 - B4B					
					Packaging 3 - 16 - B4B					
					Packaging 3 - 17 - B4B					
					Packaging 3 - 18 - B4B					
					Packaging 3 - 19 - B4B					
					Packaging 3 - 20 - B4B					
					Packaging 3 - 21 - B4B					
					Packaging 3 - 22 - B4B	AB 19-6-17				
					Packaging 3 - 23 - B4B					
					Packaging 3 - 24 - B4B					
					Packaging 3 - 25 - B4B					
					Packaging 3 - 26 - B4B					
					Packaging 3 - 27 - B4B					
					Packaging 3 - 28 - B4B					
					Packaging 3 - 29 - B4B					
					Packaging 3 - 30 - B4B					
					Packaging 3 - 31 - B4B					
					Packaging 3 - 32 - B4B					
					Packaging 3 - 33 - B4B					
					Packaging 3 - 34 - B4B					
					Packaging 3 - 35 - B4B					
					Packaging 3 - 36 - B4B					
					180 QC 21 - FG	1 pcs	3/29/19	0.00 0.00	QC 21 - FG - 21	DAS
									QC 21 - FG - 70	21
									QC 21 - FG - 53	9-30 JUN 17 2019

Part Op 100 - (Chemical Conversion Coat per QSI005 4.1) Alodine prior to sending the extrusion to an outside vendor.
 Descriptions: 105 - (QC7-Inspect Chemical Conversion Coat)
 110 - Issue P/O to Tube Caron: _____ Manufacture D135-1027-153 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6025-120** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required
 120 - (Receive & Inspect for Damage & Mat'l Certs) Ensure material release note is attached
 130 - (QC6- All purchased or subcontracted products)
 132 - (Crosstube Grinding Booth) REMOVE ALL MARK AS PER DWG
 135 - (QC15- Crosstube Dimensional Check)
 140 - ISSUE P/O: 43731 C OF C IS REQUIRED
 150 - (Receive & Inspect for Damage & Mat'l Certs) C OF C IS REQUIRED
 160 - (QC6- All purchased or subcontracted products)
 170 - (Identify as per dwg & Stock Location: LG050)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6025-120	Crosstube Material	1 Ea (1 ea)	100-Handfinish - 1 - Chemical	S152385
D435-1027-153P	Mid Height Fwd Crosstube	1 pes (1 ea)	120-Packaging 2-1 - Receive - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Handfinish - 1 - Chemical	D6025-120	1	54	0
120-Packaging 2-1 - Receive - B4B	D135-1027-153P	1	4	0

Part Specifications
Specifications could not be found.

Plex 3/15/19 1:38 PM Dart.Hadley.Shannon



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D135-1027-153
Job Sheet 190560



Part No: D135-1027-153

Job Qty: 1 ea

Part Name: Mid Height Fwd Crosstube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/11/19

Job Tracking No:

Due Date: 3/29/19

Created By: Jesse White

Type: SOLD

Description:

Note: D135-1027-153 REV.B IPP REV:A 17.01.24 NEW ISSUE DD VERF:JLM IPP REV:B 18.01.02 AS PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/29/19	0.00	0.00			
100	HandFinish	1 pcs		3/29/19	0.00	0.17	HandFinish1		
105	QC	1 pcs		3/29/19	0.00	0.00	QC7-5		
110	Purchasing	1 pcs		3/29/19	0.00	0.00	Purchasing		
120	Packaging	1 pcs		3/29/19	0.00	0.00	Packaging2		
130	QC	1 pcs		3/29/19	0.00	0.00	QC6		
132	Crosstubes	1 pcs		3/29/19	0.00	1.00	Crosstube Grinding Booth		
135	QC	1 pcs		3/29/19	0.00	0.00	QC15		
140	Outsource	1 pcs		3/29/19			SKY002-VC	2	
150	Packaging	1 pcs		3/29/19	0.00	0.00	Packaging2		
160	QC	1 pcs		3/29/19	0.00	0.00	QC6		
170	Packaging	1 pcs		3/29/19	0.00	0.00	Packaging3-1		
180	QC21-FG	1 Ea		3/29/19	0.00	0.00	QC21		

Part Op 100 - Alodine prior to sending the extrusion to an outside vendor.

Descriptions: 110 - Issue P/O to Tube Caron: 042567 Manufacture D135-1027-153 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6025-120** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required

120 - Ensure material release note is attached

132 - REMOVE ALL MARK AS PER DWG

140 - ISSUE P/O: _____ C OF C IS REQUIRED

150 - C OF C IS REQUIRED

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6025-120	Crosstube Material	1 Ea (1 ea)	90-Start up Operation	
D135-1027-153P	Mid Height Fwd Crosstube	1 pcs (1 ea)	120-Packaging	

DAS
10
9-89

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6025-120	1	54	0
120-Packaging	D135-1027-153P	1	4	0
Part Specifications				
Specifications could not be found.				

Plex 2/11/19 12:48 PM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042567



Supplier: TUB001-VC
Tube Caron Inc.
99 Louis-Joseph-Doucet Street
Lanoraie
QC
JOK 1EO Canada
Phone: 450-887-2766
Fax: 450-887-2897

PO No: PO042567
PO Date: 2/11/19
Due Date: 3/22/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	190567	D135-1027-253	Mid Height Aft Crosstube (Purchasing) Issue P/O to Tube Caron: Manufacture D135-1027-253 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6027-115** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00

1X MAR 21 2019

Line Item Note

REV C											
190568	1X	MAR 21 2019	Firmed	-		3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
190569	1X	MAR 21 2019	Firmed	-		3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
191900	1X	MAR 21 2019	Firmed	-		3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
191901	1X	MAR 21 2019	Firmed	-		3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Sub Total:							5	0	5		\$1,500.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042567



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
12	190489	D135-1027-251	Std Height Aft Crosstube Issue P/O to Tube Caron: Manufacture D135-1027-251 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6026-110** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
1X MAR 21 2019 Signature											
Line Item Note REV D											
	190571	1X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
	190572	1X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
	191903	1X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
	191905	1X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
	191907	1X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Sub Total:							6	0	6		\$1,800.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042567



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	190560	D135-1027-153	Mid Height Fwd Crosstube Issue P/O to Tube Caron: Manufacture D135-1027-153 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6025-120** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
DAS 9 3-89 1 X MAR 2 1 2019 8											
Line Item Note REV B											
	190562	1 X MAR 2 1 2019	Firmed	-		3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
	190564	1 X MAR 2 1 2019	Firmed	-		3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
	191909	1 X MAR 2 1 2019	Firmed	-		3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
	191910	1 X MAR 2 1 2019	Firmed	-		3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Sub Total:							5	0	5		\$1,500.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042567



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	190575	D135-1027-151	Std Height Fwd Crosstube Purchasing - Issue P/O to Tube Caron: Manufacture D135-1027-151 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6025-120** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. *** Material release note is required	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Line Item Note REV D 190576 1 X MAR 2 1 2019 191908 1 X MAR 2 1 2019 Sub Total: 3 0 3 \$900.00											

Grand Total: \$5,700.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/21/19 12:52 PM dart.Lussier.Patrick



SHIPPING BILL

BOL 14944**13/03/2019****Tube Caron Inc.**

99 Louis-Joseph-Doucet
Lanoraie, QC, Canada
J0K 1E0
Phone: 450-887-2766

Fax: 450-887-2897

Ship To:

Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON, Canada
K6A 1K7
Phone : 613-632-1053

Fax : 613-632-4443

Sold To:

Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON, Canada
K6A 1K7
Phone : 613-632-5200

Fax : 613-632-4443

Third Party Billing:

Ln	Item	Qty	Po	Job	Weight	UOM
1	PALETTE	1			20.00	Pounds
	D135-1027-151 REV D	1	PO042567	J21867-11	13.36	Pounds
	D135-1027-151 REV D	1	PO042567	J21867-12	13.36	Pounds
	D135-1027-151 REV D	1	PO042567	J21867-16	13.36	Pounds
	D135-1027-153 REV B	1	PO042567	J21867-10	14.57	Pounds
	D135-1027-153 REV B	2	PO042567	J21867-15	29.14	Pounds
	D135-1027-153 REV B	1	PO042567	J21867-8	14.57	Pounds
	D135-1027-153 REV B	1	PO042567	J21867-9	14.57	Pounds
	D135-1027-251 REV D	1	PO042567	J21867-5	16.21	Pounds
	D135-1027-251 REV D	1	PO042567	J21867-6	16.21	Pounds
2	PALETTE	1			20.00	Pounds
	D135-1027-251 REV D	3	PO042567	J21867-14	48.64	Pounds
	D135-1027-251 REV D	1	PO042567	J21867-7	16.21	Pounds
	D135-1027-253 REV C	1	PO042567	J21867-1	19.81	Pounds
	D135-1027-253 REV C	2	PO042567	J21867-13	39.62	Pounds
	D135-1027-253 REV C	1	PO042567	J21867-2	19.81	Pounds
	D135-1027-253 REV C	1	PO042567	J21867-3	19.81	Pounds
	D135-1027-253 REV C	1	PO042567	J21867-4	19.81	Pounds

Carrier:

Phone:

Way Bill:

Journey Freight

1-888-633-1252 #3221

Fob:

Freight Charges:

Fob Lanoraie

Collect

Total Of Packages :

2 PALETTES

Carrier : Journey Freight

96 X 32 X 36

96 X 32 X 36

Total Weight:

369.06 #

Shipper : Tube Caron Inc.

Declared Value :

(No Additional Insurance Required)

Not Applicable For Insurance Purposes

14-03-2019

CERTIFICATE OF CONFORMANCE

CUSTOMER : Dart Aerospace

DATE : March 21, 2019

P.O.# PO042567

I certify that the following parts were manufactured to the specifications stated on the drawings listed below.

Note: Material for manufacturing of parts is provided by Dart Aerospace.

PART NO.	QTY.	DRAWING NO. / REV.
D135-1027-253 ✓ MID HEIGHT AFT XTUBE	6 ✓	D135-1027-253 / REV.C
D135-1027-153 ✓ MID HEIGHT FWD XTUBE	5 ✓ DAS 9 9.20	D135-1027-153 / REV.B
D135-1027-151 ✓ STD HEIGHT FWD XTUBE	3 ✓	D135-1027-151 / REV.D
D135-1027-251 ✓ STD HEIGHT AFT XTUBE	6 ✓	D135-1027-153 / REV.D

Sincerely,

Kevin Gadoury

Kevin Gadoury

DART AEROSPACE LTD		Work Order: 190560
Description: MID HEIGHT FWD CROSSTUBE		Part Number: D135-1027-153
Inspection Dwg: D135-1027-153 Rev: B		Page 1 of 2

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.550" TYP	+/-0.005"					
13.63" TYP	+/-0.030"					
2.14" REF	+/-0.030"					
2.75" TYP	+/-0.030"					
Ø.194" THUR 2PL	+0.006" -0.001"					
17.0" 2PL	+/-0.100"					
Ø.313" THUR 2PL	+0.006" -0.001"					
Ø.472" THUR 4PL	+0.006" -0.001"					

WALL THICKNESS MEASUREMENTS

LOCATION FROM CL	DWG DIM	R1	R2	R3	R4				
CL	0.134"								
21"	0.134"								
21"	0.134"								
CENTER OF BEND	0.134"								
CENTER OF BEND	0.134"								

OUTSIDE DIAMETER MEASUREMENTS

Location	DWG DIM	M1	M2				
CL	3.543"						
CENTER OF BEND	3.543"						
CENTER OF BEND	3.543"						

Crushing

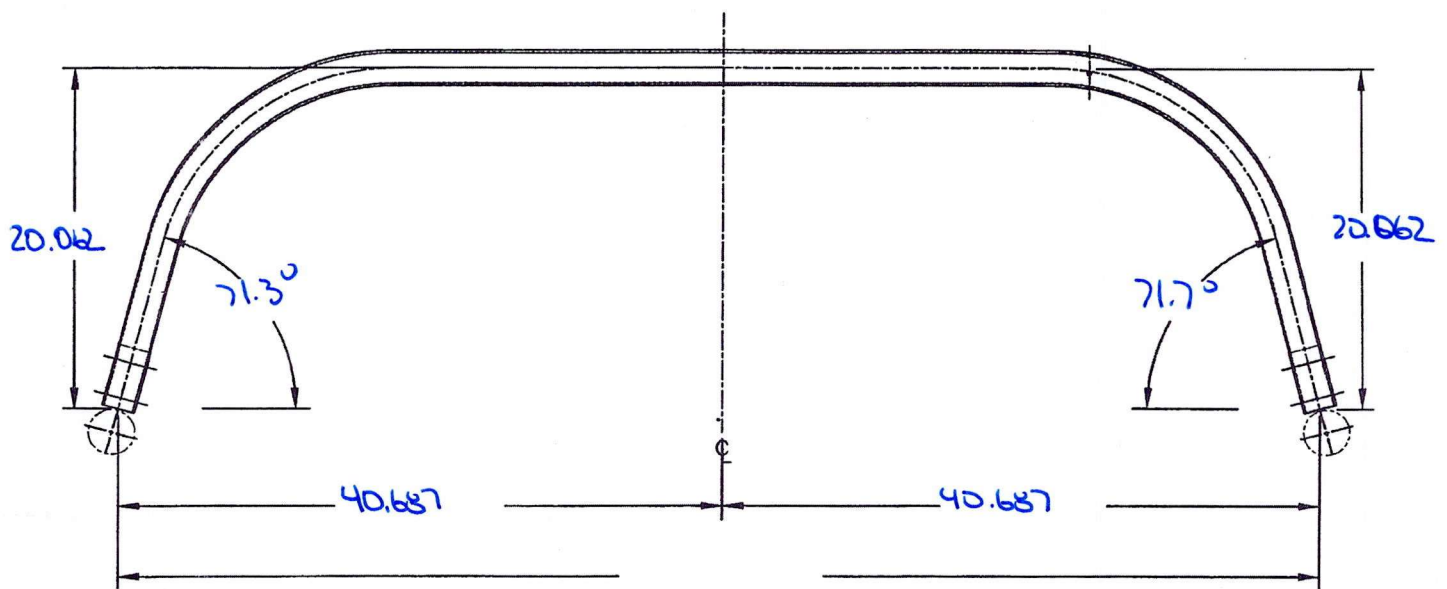
	Side A	Side B
MAX 2%	.54%	.37%

TWIST

	SIDE A	SIDE B
MAX 0.25"		

DART AEROSPACE LTD		Work Order: 190360
Description: MID HEIGHT FWD CROSSTUBE		Part Number: D135-1027-153
Inspection Dwg: D135-1027-153 Rev: B		Page 2 of 2

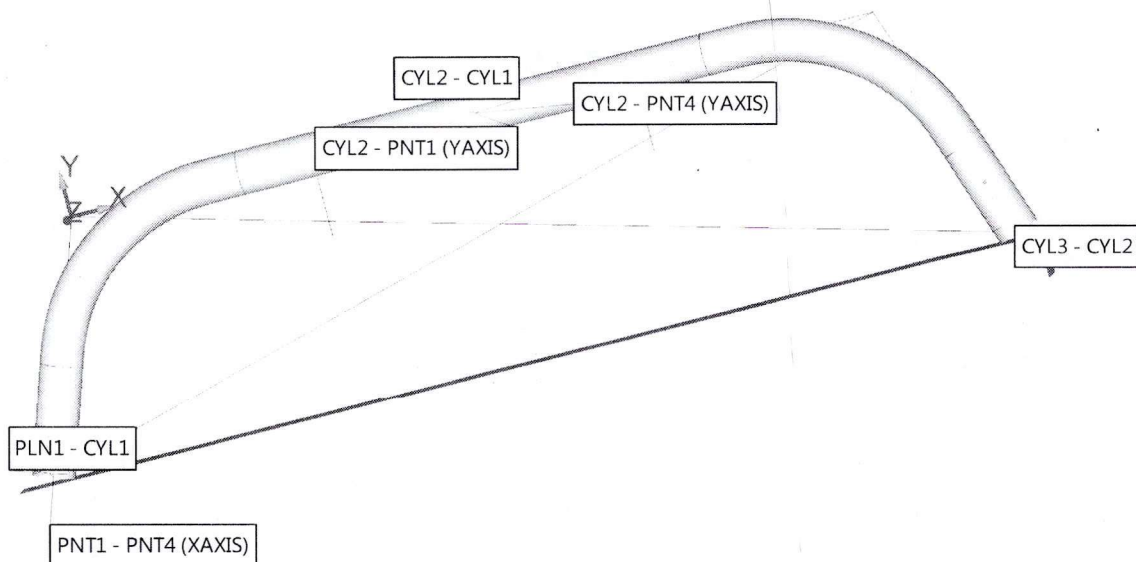
Required Dimension	Min	Max
Height	19.85"	20.11"
1/2 Span	40.60"	40.86"
Angle	70°	72°
Total Span	81.20"	81.72"
Bending Passes		
Crushing	0%	2%



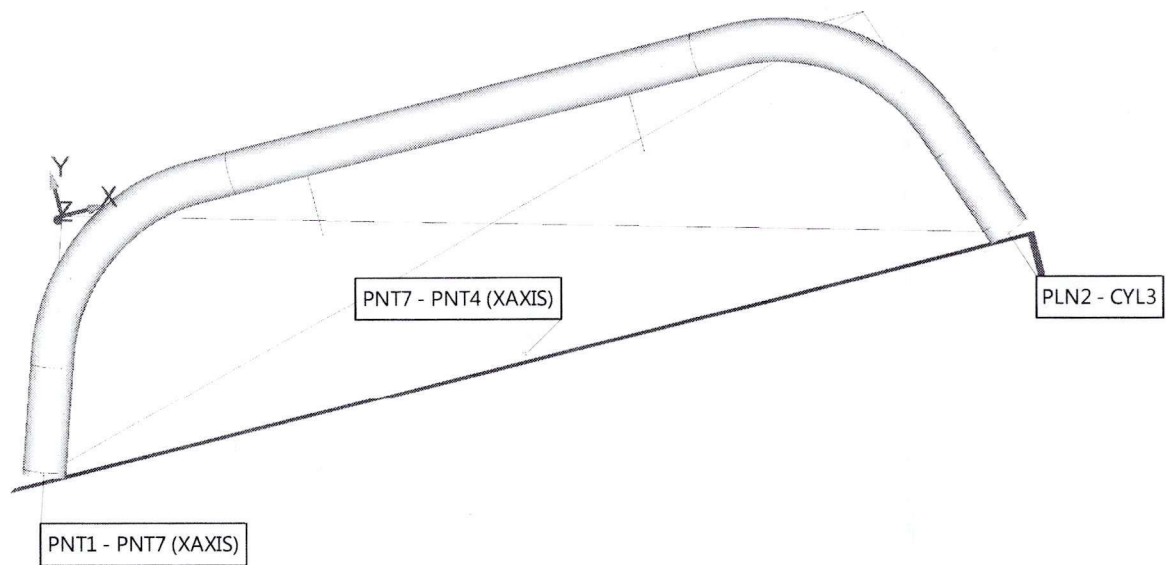
Measured by:		Checked by:		QC Inspector:	
Date:		Date:		Date:	

Engineering Approval: (If necessary)		Date:	
--	--	--------------	--

Rev	Date	Change	Revised by	Approved
A	18/01/16	New Issue	ED	



pcodmis		PART NAME : D135-1027-153_Plage+Coupe				mars 09, 2019		13:21	
		REV NUMBER : Rev.B		SER NUMBER : 3164580		STATS COUNT : 1			
∠	DEG		ANGL1 - CYL2 TO CYL1						
AX	NOMINAL		+TOL	-TOL	MEAS	DEV	OUTTOL		
A	71.0000		0.5000	0.5000	70.8852	-0.1148	0.0000		
∠	DEG		ANGL2 - CYL3 TO CYL2						
AX	NOMINAL		+TOL	-TOL	MEAS	DEV	OUTTOL		
A	71.0000		0.5000	0.5000	70.9870	-0.0130	0.0000		
↔	IN		DIST1 - PNT1 TO PNT4 (XAXIS)						
AX	NOMINAL		+TOL	-TOL	MEAS	DEV	OUTTOL		
M	81.4700		0.2500	0.2500	81.4732	0.0032	0.0000		
↔	IN		DIST2 - CYL2 TO PNT1 (YAXIS)						
AX	NOMINAL		+TOL	-TOL	MEAS	DEV	OUTTOL		
M	19.9800		0.1300	0.1300	19.9686	-0.0114	0.0000		
↔	IN		DIST3 - CYL2 TO PNT4 (YAXIS)						
AX	NOMINAL		+TOL	-TOL	MEAS	DEV	OUTTOL		
M	19.9800		0.1300	0.1300	20.0138	0.0338	0.0000		
∠	DEG		ANGL3 - PLN1 TO CYL1						
AX	NOMINAL		+TOL	-TOL	MEAS	DEV	OUTTOL		
A	90.0000		0.5000	0.5000	89.6904	-0.3096	0.0000		



∠	DEG	ANGL5 - PLN2 TO CYL3				
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL
A	-90.0000	0.5000	0.5000	-89.7841	0.2159	0.0000
↔	IN	DIST4 - PNT1 TO PNT7 (XAXIS)				
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL
M	40.7350	0.1300	0.1300	40.7366	0.0016	0.0000
↔	IN	DIST5 - PNT7 TO PNT4 (XAXIS)				
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL
M	40.7350	0.1300	0.1300	40.7366	0.0016	0.0000



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043731



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Attention: Jenne, Heather

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043731

PO Date: 6/14/19

Due Date: 6/18/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	191909	D135-1027-153	ISSUE P/O: _____ C OF C IS REQUIRED	Firmed	-	6/18/19	1 pcs	0 pcs	1 pcs	\$147.50/pcs	\$147.50
	190564		JUN 14 2019	Firmed	-	6/18/19	1 pcs	0 pcs	1 pcs	\$147.50/pcs	\$147.50
	190560		JUN 14 2019	Firmed	-	6/18/19	1 pcs	0 pcs	1 pcs	\$147.50/pcs	\$147.50
	191910		JUN 14 2019	Firmed	-	6/18/19	1 pcs	0 pcs	1 pcs	\$147.50/pcs	\$147.50
	190562		JUN 14 2019	Firmed	-	6/18/19	1 pcs	0 pcs	1 pcs	\$147.50/pcs	\$147.50
Sub Total:							5	0	5		\$737.50

2	196120	D407-667-105	Fwd Crosstube - High 407 : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** OUTSIDE SERVICE -CROSSTUBES Liquid Penetrant Inspection as per QSI 038 Or Level 2 Attach copy of NDT results to work order	Firmed	-	6/18/19	1 pcs	0 pcs	1 pcs	\$147.50/pcs	\$147.50
	192352		JUN 14 2019	Firmed	-	6/18/19	1 pcs	0 pcs	1 pcs	\$147.50/pcs	\$147.50
	192353		JUN 14 2019	Firmed	-	6/18/19	1 pcs	0 pcs	1 pcs	\$147.50/pcs	\$147.50
	192354		JUN 14 2019	Firmed	-	6/18/19	1 pcs	0 pcs	1 pcs	\$147.50/pcs	\$147.50
Sub Total:							4	0	4		\$590.00

DAS
40
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043731



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	192615	D3011-1	Rappel Slide Bar : Various STC's (Outsource process - NDT per QSI038 4.1)1- LPI AS PER ASTM 1417 LEVEL 2 AS PER DWG D3011 2- Certificate of conformity is required	Firmed	-	6/18/19	5 pcs	0 pcs	5 pcs	\$29.50/pcs	\$147.50
Grand Total:											\$1,475.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/14/19 3:45 PM Dart.Guerin.Kimberley

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO40756	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: POHB043731
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	

Task: **UNSCHEDULED**

Sequence: 1

Work Required:

CARRY OUT NDT ON:

- ✓ 5 RAPPEL SLIDE BARS , P/N# D3011-1 , J/S# 192615 ✓
- ✓ 4 FWD CROSSTUBES , P/N# D407-667-105 , J/S# 196120 , 192352 , 192353 , 192354 ✓
- ✓ 5 MID HEIGHT FWD CROSSTUBES , P/N# D135-1027-153 , J/S# 191909 , 190564 , 190560 , 191910 , 190562 ✓

DAS
40
9-89

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-16						JUN 14 2019	
NO CRACK FOUND							
PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

RECEIVED

JUN 14 2019

DART AEROSPACE LTD.

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp 	Date:
Name: RAFIK MELIKIAN		JUN 14 2019